



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D350-636-012
Job Sheet 196903



Part No: D350-636-012

Job Qty: 1 pcs

Part Name: Skidtube RH, Std Wearplates, DART (Apical) Cylindrical/Aerazur Float Comp.



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 6/24/19

Job Tracking No:

Due Date: 7/20/19

Created By: Kimberley Guerin

Type: Stock

Description:

Note: DWG D2750-042 REV.H IPP Rev:I 02.09.25 IPP Rev:J 06-03-23 As per Rev D IPP Rev:K 06-07.13 As per dsi9343 IPP Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Verf:EC IPP Rev:M 08-04-22 DD verified:EC IPP Rev:N 08-09-23 revF DD verified:ec IPP Rev:O 09-02-06 per PAR09-010 DD verf:EC IPP Rev:P 10.06.22 revise seq110 DD verf:EC IPP Rev:Q 10.10.01 as per IIN revH DDverf:EC IPP REV:R 13.08.27 PER ECN13-594 DD VERF:JLM IPP REV:S 18.11.12 AS PER DWG REV.H DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard Setup Hrs	Run Hrs	Workcenter/Supplier	Lead Time	Sign-off
110	Skidtubes - 1	1 pcs	7/20/19		0.00	4.36	Skidtubes - 1		
							Skidtubes - 2		
							Skidtubes - 3		
							Skidtubes - 4		
							Skidtubes - 5		
							Skidtubes - 6		
							Skidtubes - 7		
120	QC 10	1 pcs	7/20/19		0.00	0.00	QC 10 - 10		
							QC 10 - 18		
							QC 10 - 24		
							QC 10 - 43		
							QC 10 - 50		
							QC 10 - 58		
							QC 10 - 9		
130	QC 5	1 pcs	7/20/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		

Plex 6/24/19 3:59 PM Dart.Guerin.Kimberley

140 Handfinish - 1-1 Chemical-B4B	1 ✓ pcs	7/20/19	0.00 0.91	QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				Handfinish - 1 - 1 - B4B ✓	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
150 QC 7	1 pcs	7/20/19	0.00 0.00	QC 7 - 10	
				QC 7 - 13	
				QC 7 - 14	
				QC 7 - 15	
				QC 7 - 17	
				QC 7 - 18	
				QC 7 - 19	
				QC 7 - 2	
				QC 7 - 28	
				QC 7 - 3	
				QC 7 - 30	
				QC 7 - 34	
				QC 7 - 36	
				QC 7 - 37	
				QC 7 - 41	
				QC 7 - 47	
				QC 7 - 48	
				QC 7 - 51	
				QC 7 - 58	
				QC 7 - 59	
				QC 7 - 60	
				QC 7 - 9	
				QC 7 - 68	

DAS

JUL 19 2019 40
9-89TUE 9-10-2019
Rosales, Oscar

DD

					QC 7 - 50	
					QC 7 - 67	
					QC 7 - 40	
					QC 7 - 24	
					QC 7 - 43	
					QC 7 - 61	
					QC 7 - 81	
160 Skidtubes - 2 - B4B	1 pcs	7/20/19	0.00 4.36	Skidtubes - 1 - B4B		
				Skidtubes - 2 - B4B		
				Skidtubes - 3 - B4B		
				Skidtubes - 4 - B4B		TF
				Skidtubes - 5 - B4B		BE
				Skidtubes - 6 - B4B		
				Skidtubes - 7 - B4B		
170 QC 10	1 pcs	7/20/19	0.00 0.00	QC 10 - 10		
				QC 10 - 18		
				QC 10 - 24		
				QC 10 - 43		
				QC 10 - 50		DAS
				QC 10 - 58		JUL 30 2019 50
				QC 10 - 9		9-89
180 QC 5	1 pcs	7/20/19	0.00 0.00	QC 5 - 10		
				QC 5 - 12		
				QC 5 - 17		
				QC 5 - 18		
				QC 5 - 19		
				QC 5 - 22		
				QC 5 - 24		
				QC 5 - 3		
				QC 5 - 43		
				QC 5 - 49		
				QC 5 - 51		
				QC 5 - 58		
				QC 5 - 68		DAS
				QC 5 - 9		JUL 30 2019 68
				QC 5 - 50		9-89
				QC 5 - 30		
				QC 5 - 40		
190 Handfinish - 2-1 Pressure-B4B	1 pcs	7/20/19	0.00 0.91	Handfinish - 2 - 1 - B4B		
				Handfinish - 2 - 2 - B4B		JUL 29 2019
				Handfinish - 2 - 3 - B4B		
				Handfinish - 2 - 4 - B4B		
200 Spray Paint - 2 - B4B	1 pcs	7/20/19	0.00 0.69	Spray Paint - 1 - B4B		RD 19-8-6
				Spray Paint - 2 - B4B		
				Spray Paint - 3 - B4B		
				Spray Paint - 4 - B4B		
205 Outsource	1 pcs	7/20/19		ATE003-VC	5	
210 QC 14	1 pcs	7/20/19	0.00 0.00	QC 14 - 15		W 19-8-21
				QC 14 - 2		
				QC 14 - 34		
				QC 14 - 41		
				QC 14 - 51		
				QC 14 - 58		
				QC 14 - 59		
				QC 14 - 9		
				QC 14 - 68		
				QC 14 - 40		
				QC 14 - 19		

				Packaging 1 - 19 - B4B	
				Packaging 1 - 20 - B4B	
				Packaging 1 - 21 - B4B	
				Packaging 1 - 22 - B4B	
				Packaging 1 - 23 - B4B	
				Packaging 1 - 24 - B4B	
				Packaging 1 - 25 - B4B	
				Packaging 1 - 26 - B4B	
				Packaging 1 - 27 - B4B	
				Packaging 1 - 28 - B4B	
				Packaging 1 - 29 - B4B	
				Packaging 1 - 30 - B4B	
				Packaging 1 - 31 - B4B	
				Packaging 1 - 32 - B4B	
				Packaging 1 - 33 - B4B	
				Packaging 1 - 34 - B4B	
				Packaging 1 - 35 - B4B	
				Packaging 1 - 36 - B4B	
260	QC 4	1	7/20/19	0.00 0.00	QC 4 - 28
		pcs			QC 4 - 58
					QC 4 - 69
					QC 4 - 9
					QC 4 - 46
					QC 4 - 68
					QC 4 - 72
					QC 4 - 74
					QC 4 - 75
270	Packaging 3-1 - Stock - B4B	1	7/20/19	0.00 0.00	Packaging 3 - 1 - B4B
		pcs			Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
					Packaging 3 - 18 - B4B
					Packaging 3 - 19 - B4B
					Packaging 3 - 20 - B4B
					Packaging 3 - 21 - B4B
					Packaging 3 - 22 - B4B
					Packaging 3 - 23 - B4B
					Packaging 3 - 24 - B4B
					Packaging 3 - 25 - B4B
					Packaging 3 - 26 - B4B
					Packaging 3 - 27 - B4B
					Packaging 3 - 28 - B4B
					Packaging 3 - 29 - B4B
					Packaging 3 - 30 - B4B
					Packaging 3 - 31 - B4B
					Packaging 3 - 32 - B4B

				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	DAS
275 DC - 1 - B4B	1 pcs	7/20/19	0.00 0.00	DC - 1 - B4B	21 SEP 12 2019
				DC - 2 - B4B	9-89
280 QC 21 - FG	1 pcs	7/20/19	0.00 0.00	QC 21 - FG - 21	DAS
				QC 21 - FG - 70	21 SEP 12 2019
				QC 21 - FG - 53	9-89

Part Op 110 - (Skid tubes) 1- Pick D2600-3 Bent Drill pilot holes as per Dwg D2750 sheet 4 (D2750-2 details). Drill using drill Jig
 Descriptions: DT8150 & DT8863A for second side only DT8863B for first side (detail K) 4- Locate DT8329 off of blade fitting bolt holes
 and drill pilot holes for blade fitting. Open to 0.500" using hole saw. VERIFY AND RECORD FWD BEND ANGLE. 6- Drill
 pilot holes for wearplates as per Dwg D2750 using DT8108 open to 0.297". 7- Open up holes of Detail J to 0.297" (total of
 2 holes per side) 8- Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill grooves in bend left from bending as per QSI
 004 9- Grind welds flush as per Dwg D2750 *AK MB901*
 120 - (QC10- Inspect visual per QSI004- ground welds)
 130 - (QC5- Inspect part completeness to step on W/O)
 140 - (Chemical Conversion Coat per QSI005 4.1)
 150 - (QC7- Inspect Chemical Conversion Coat)
 160 - (Skid tubes) 1- Open up holes of Detail L using hole saw and ground handling to 0.625" (total of 8 holes per side) as
 per dwg D2750. 2- Open up holes of Detail K using hole saw to 0.750" (total of 4 holes per side) as per dwg D2750. 3-
 Open float holes using uni-bit to .500" (4 per Side) 4- Chamfer holes of Detail K, L, ground handling and float holes per
 dwg D2750 (welding instructions on sheet 9) 5- Deburr and blow out all chips from inside of tube 6- Prepare tube for
 welding, remove alodine as required. 7- Bond web D2739 in place as per QSI 015, let cure for 12hrs. A/R Sikaflex-291
 batch: 5174342 exp. date: 12.08.19 **ATTN: USE I-BEAM LOCATION AID (BLADE FITTING)** 8- Weld spacers
 D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004 (welding instructions on sheet 9) A/R Aluminum Rod
 batch: 5178812 9- At section AP-AP drill out x-bolt spacer to 0.404" 10- Grind welds flush as per Dwg D2750 11- Spot
 face ground handling holes section (total of 4 places per side) as per dwg D2750 12- Deburr holes, ensure tube is free of
 all scratches before sending to paint.
 170 - (QC10- Inspect visual per QSI004- ground welds)
 180 - (QC5- Inspect part completeness to step on W/O) ***VERIFY C'BOARD IS GOOD***
 190 - (Pressure Wash per QSI005 4.3/ Clean and remove all markings) Re-alodine tube as per QSI 005 section 4.1.2.1 do
 not acid etch.
 200 - (Spray Paint / NDT Room) 1- PRIME AS PER DWG AND QSI 005 4.2 PRIMER PRC DESOTO 515X349
 BATCH: 5198114 2- PAINT WHITE AS PER DWG AND QSI 005 4.2 PAINT BATCH: 5198381
 210 - (QC14- Inspect Spray Paint) Inspect for foreign object per QSI 024
 230 - (Assemble as per dwg) 1- Install inserts as per dwg D2750 2- Inspect for Foreign Objects 3- Install blade fitting
 D3488-042, wearshoes and ground handling hardware as per dwg D2750 SIKAFLEX 241 BATCH: 5174342 EXP
 DATE: 14-12-19 4- assemble o-ring to plug as per dwg D3492 and apply o-ring lube A/R 55-o-ring lube
 batch: 5178812 5- Coat all exposed fasteners with "LPS Procyon" batch: 5133160
 240 - (QC5- Inspect part completeness to step on W/O)
 250 - (Pick Kit)
 260 - (QC4- 100% Inspect kits for completeness)
 270 - (Identify as per dwg & Stock Location: 89.8) Package as per PPP D350-636-012
 275 - (Document Control) record fwd angle: 89.8 Photocopy blue file and type labels per PPP D350-636-012
 CHG 008
 280 - (QC21- Final Inspection - Work Order Release)

Job BOM

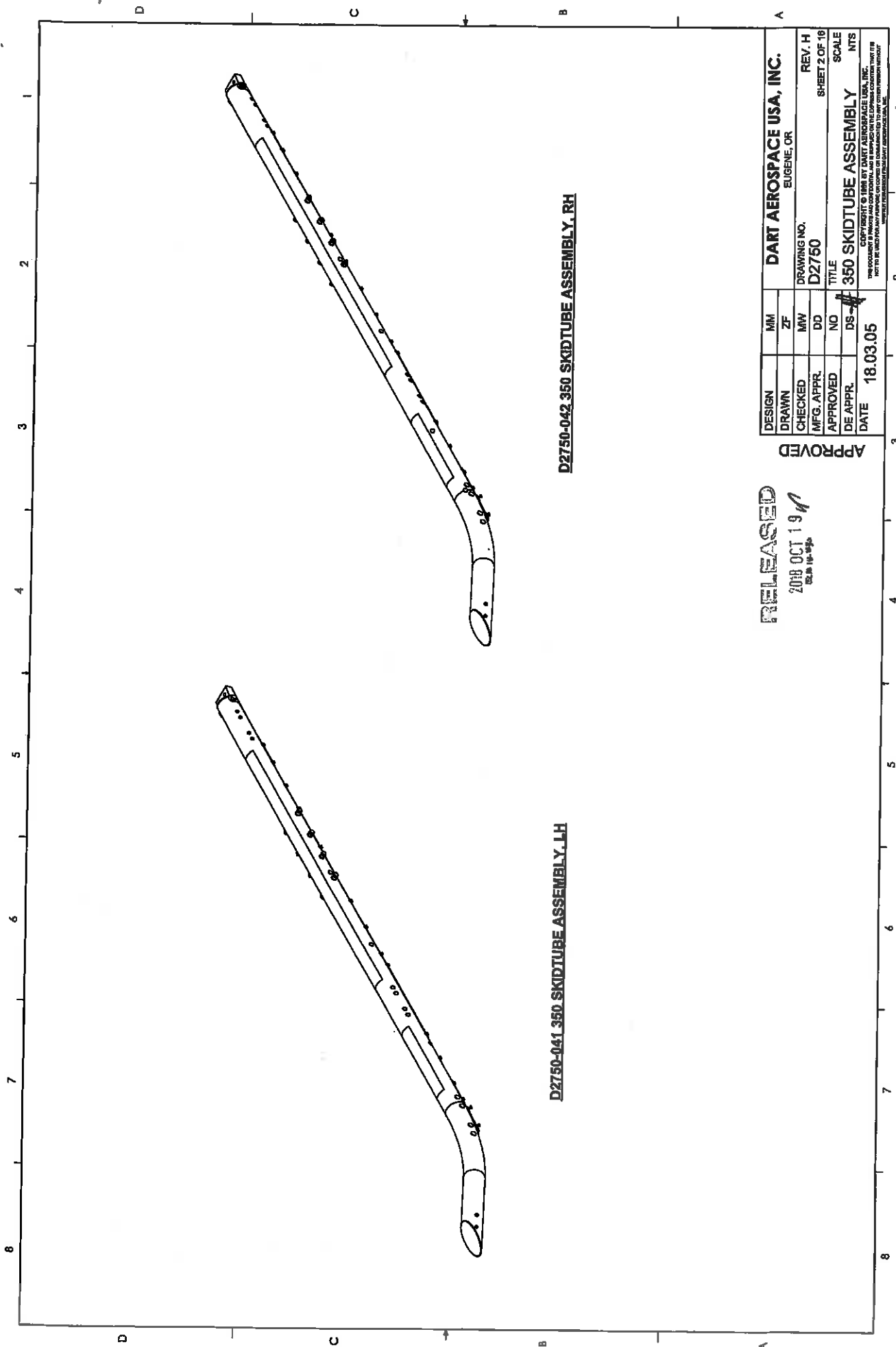
Part / Item	Component Name	Quantity	Operation	Container
D2600-3-BENT-RH	Extrusion Bent RH	1 pcs (1 ea)	110-Skidtubes - 1	017617 S182195
D2744	Cap	1 pcs (1 ea)	110-Skidtubes - 1	S192776
D2739	350 I-Beam	1 pcs (1 ea)	160-Skidtubes - 2 - B4B	S193743
D2743	Crossbolt Spacer	8 pcs (8 ea)	160-Skidtubes - 2 - B4B	S182366
D3490-1	Cross Bolt Spacer	4 pcs (4 ea)	160-Skidtubes - 2 - B4B	S186298
D3490-3	Cross Bolt Spacer	4 pcs (4 ea)	160-Skidtubes - 2 - B4B	S188671
ALS4-1032-225	Rivnut	38 Ea (38 ea)	230-Handfinish - 4-1-Assembly-B4B	S174309
AN3C5A	Bolt	34 Ea (34 ea)	230-Handfinish - 4-1-Assembly-B4B	S167161
AN3C6A	Bolt	4 Ea (4 ea)	230-Handfinish - 4-1-Assembly-B4B	S167183
AN6C44A	Bolt	4 Ea (4 ea)	230-Handfinish - 4-1-Assembly-B4B	S184102
AN8C35A	Bolt	1 Ea (1 ea)	230-Handfinish - 4-1-Assembly-B4B	S167096
D2745	Bushing	8 pcs (8 ea)	230-Handfinish - 4-1-Assembly-B4B	S206359
D3488-4	Blade Fitting, RH	1 pcs (1 ea)	230-Handfinish - 4-1-Assembly-B4B	S185284
D3492-1	Plug	8 pcs (8 ea)	230-Handfinish - 4-1-Assembly-B4B	S183175
D3492-3	Plug	8 pcs (8 ea)	230-Handfinish - 4-1-Assembly-B4B	S205435
D3537-1	Wearpad	3 pcs (3 ea)	230-Handfinish - 4-1-Assembly-B4B	S204500
D3631-1	Washer	8 pcs (8 ea)	230-Handfinish - 4-1-Assembly-B4B	S184192
D3791-1	Wearpad	1 pcs (1 ea)	230-Handfinish - 4-1-Assembly-B4B	S201871
D3793-1	Wearplate Fwd	1 pcs (1 ea)	230-Handfinish - 4-1-Assembly-B4B	* S210630
D3793-3	Wearplate Aft	1 pcs (1 ea)	230-Handfinish - 4-1-Assembly-B4B	S20007
MS21043-6	Nut	4 Ea (4 ea)	230-Handfinish - 4-1-Assembly-B4B	S166469
MS21083C8	Nut	1 Ea (1 ea)	230-Handfinish - 4-1-Assembly-B4B	S167203-1
NAS1149C0332R	Washer (AN960C10L)	38 Ea (38 ea)	230-Handfinish - 4-1-Assembly-B4B	S1276017
NAS1149C0832R	Washer (AN960C816L)	1 Ea (1 ea)	230-Handfinish - 4-1-Assembly-B4B	S193136
NAS1515H3L	Washer	4 Ea (4 ea)	230-Handfinish - 4-1-Assembly-B4B	S083559
NAS1611-010	O-Ring	8 Ea (8 ea)	230-Handfinish - 4-1-Assembly-B4B	S057659
NAS1611-013	O-Ring	8 Ea (8 ea)	230-Handfinish - 4-1-Assembly-B4B	S170222
D3793-5	Wearpad	1 pcs (1 ea)	230-Handfinish - 4-1-Assembly-B4B	S201919
AN8C21A	Bolt	2 Ea (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	S184404
D2741	Replacement Blade	1 pcs (1 ea)	250-Packaging 1-1 - Pick Kit - B4B	S197663
D3493-1	Washer	2 pcs (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	S199486
D3532-1	Spacer	2 pcs (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	S163195
MS21083C8	Nut	2 Ea (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	S192757
NAS1149D0863J	Washer	2 Ea (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	S166718

TUE 9-10-2019

Rosales, Oscar

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
110-Skidtubes - 1	D2600-3-BENT-RH	1	3	0
	D2744	1	58	0
160-Skidtubes - 2 - B4B	D2739	1	9	0
	D2743	8	103	0
	D3490-1	4	169	0
	D3490-3	4	62	0
	ALS4-1032-225	38	916	0
230-Handfinish - 4-1-Assembly-B4B	AN3C5A	34	986	0
	AN3C6A	4	153	0
	AN6C44A	4	126	0
	AN8C35A	1	31	0
	D2745	8	72	0
	D3488-4	1	13	0
	D3492-1	8	75	0
	D3492-3	8	31	0
	D3537-1	3	32	0
	D3631-1	8	400	0
	D3791-1	1	6	0
	D3793-1	1	9	0
	D3793-3	1	3	0
	D3793-5	1	4	0
	MS21043-6	4	119	0
	MS21083C8	1	118	0
	NAS1149C0332R	38	5,234	0
	NAS1149C0832R	1	303	0
	NAS1515H3L	4	185	0
	NAS1611-010	8	227	0
	NAS1611-013	8	124	0
250-Packaging 1-1 - Pick Kit - B4B	AN8C21A	2	145	0
	D2741	1	31	0
	D3493-1	2	29	0
	D3532-1	2	51	0
	MS21083C8	2	118	0
	NAS1149D0863J	2	399	0
Part Specifications				
Specifications could not be found.				

Plex 6/24/19 3:59 PM Dart.Guerin.Kimberley



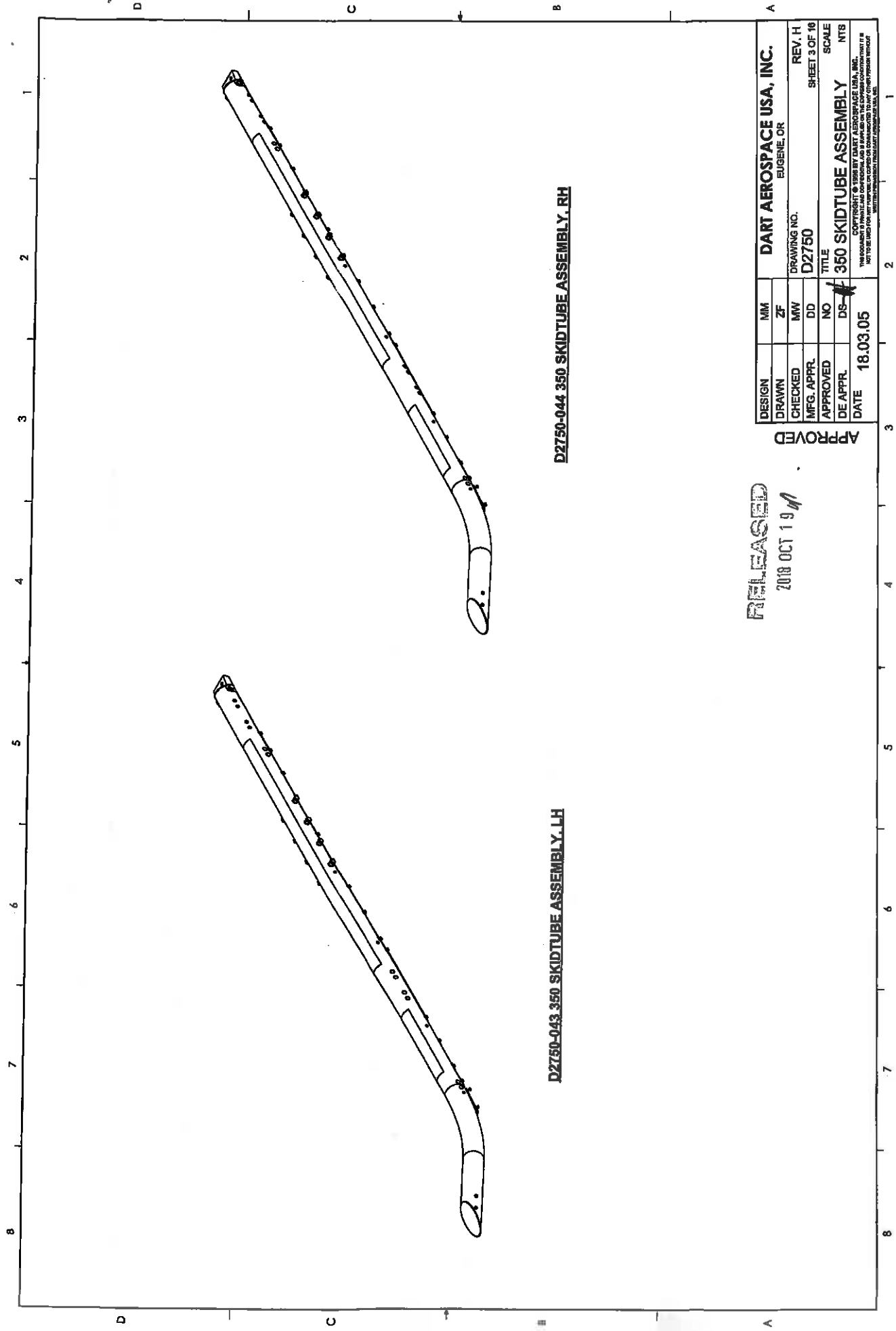
D2750-041 350 SKIDTUBE ASSEMBLY, LH

D2750-042 350 SKIDTUBE ASSEMBLY, RH

RELEASED
2008 OCT 19
CS 10-10-90

APPROVED

DESIGN	MM	DART AEROSPACE USA, INC.	
DRAWN	ZF	EUGENE, OR	
CHECKED	MW	DRAWING NO.	REV. H
MFG. APPR.	DD	D2750	SHEET 2 OF 18
APPROVED	NO	TITLE	SCALE
DE APPR.	DS	350 SKIDTUBE ASSEMBLY	NTS
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D2750-043 350 SKIDTUBE ASSEMBLY, LH

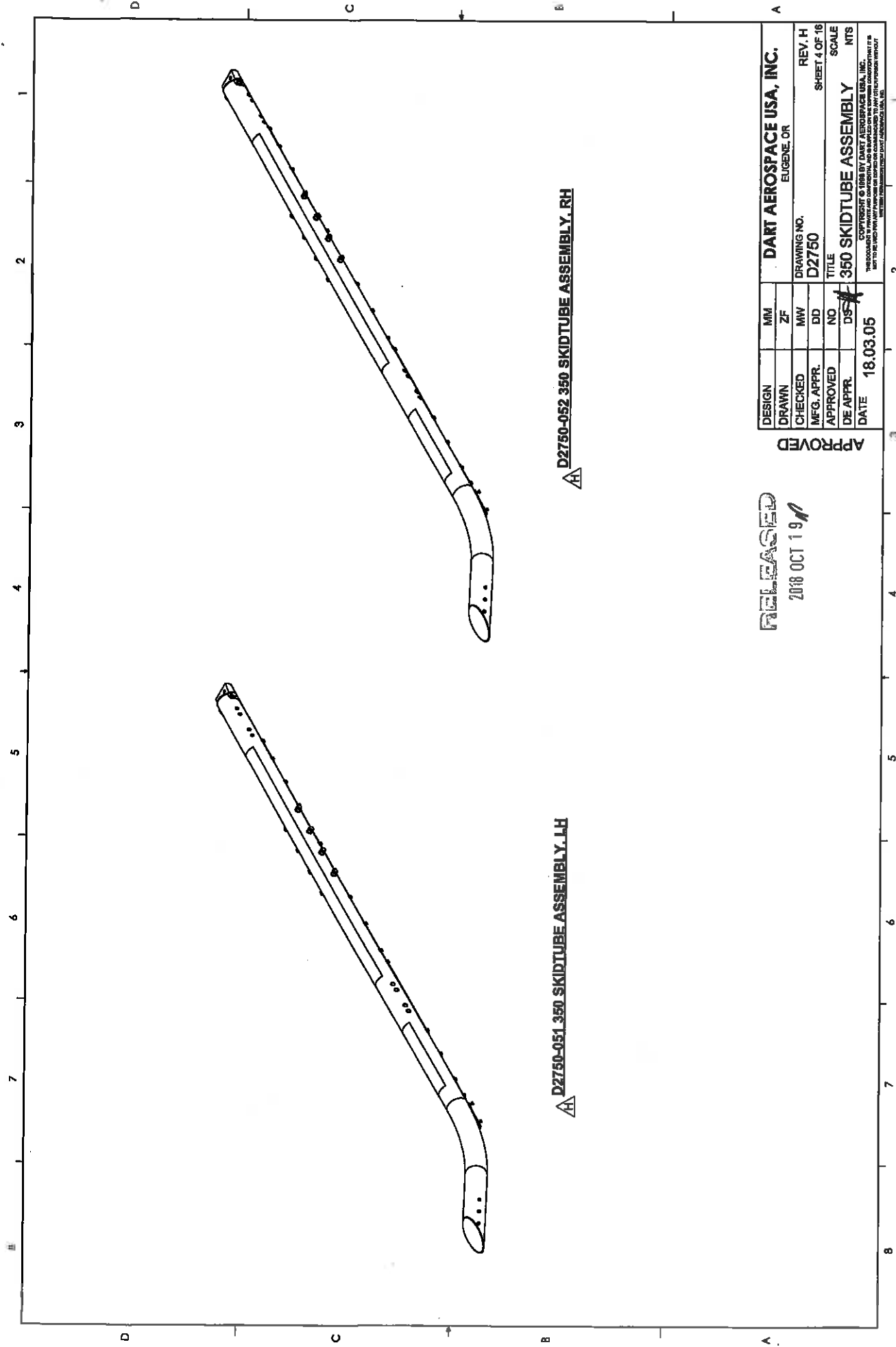
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2018 OCT 19

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CHECKED	MM		DRAWING NO.	REV. H
MFG. APPR.	DD		D2750	SHEET 3 OF 10
APPROVED	NO		TITLE	SCALE
DATE	DS	18.03.05	350 SKIDTUBE ASSEMBLY	NTS

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A D2750-051 350 SKIDTUBE ASSEMBLY, LH

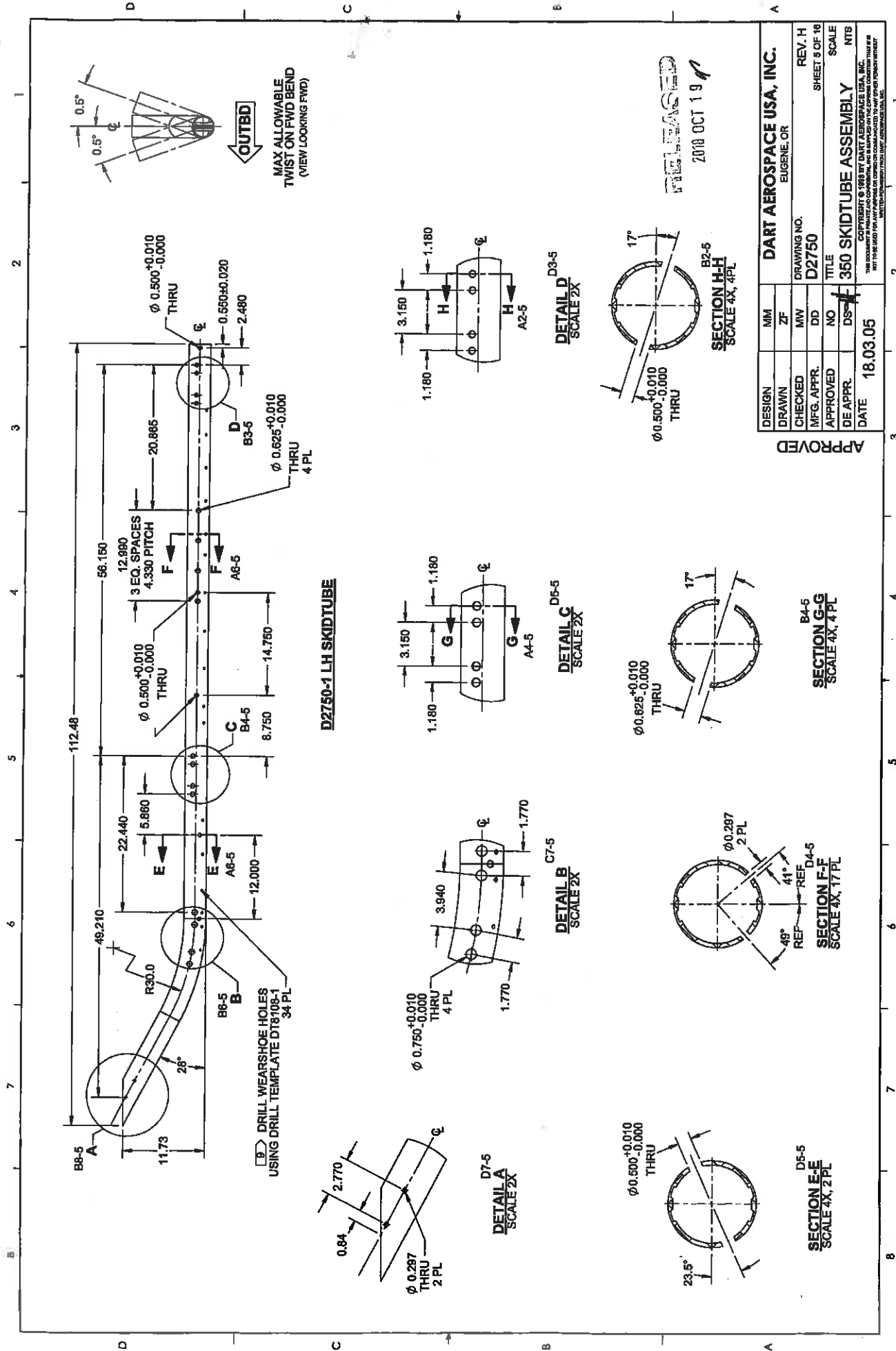
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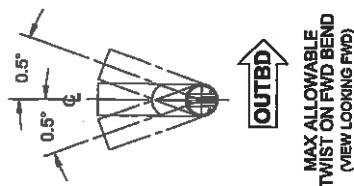
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2018 OCT 19

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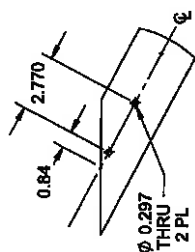
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APPROVED	NO	SHEET 4 OF 16
DE APPR.	DS	TITLE 350 SKIDTUBE ASSEMBLY
DATE 18.03.05		SCALE NTS

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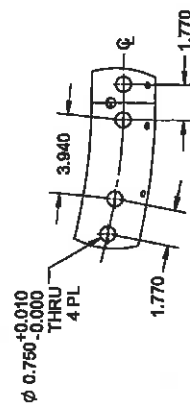




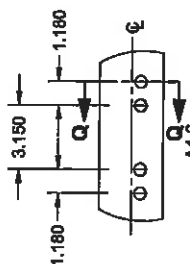
D2750-2 RH SKIDTUBE



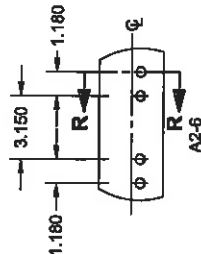
D7-6
DETAIL J
SCALE 2X



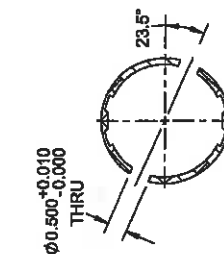
DETAIL K
SCALE 2X



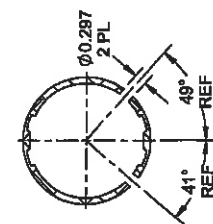
D5-6



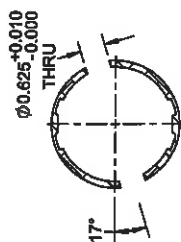
D3-6
DETAIL M
SCALE 2X



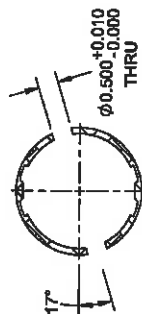
D6-8
SECTION N-N
SCALE 4X 2 PL



D4-6
SECTION P-P
SCALE 4X, 17 PL



B4-6
SECTION Q-Q
SCALE 4X 45'



SECTION R-R
SCALE 4X, 4 PL

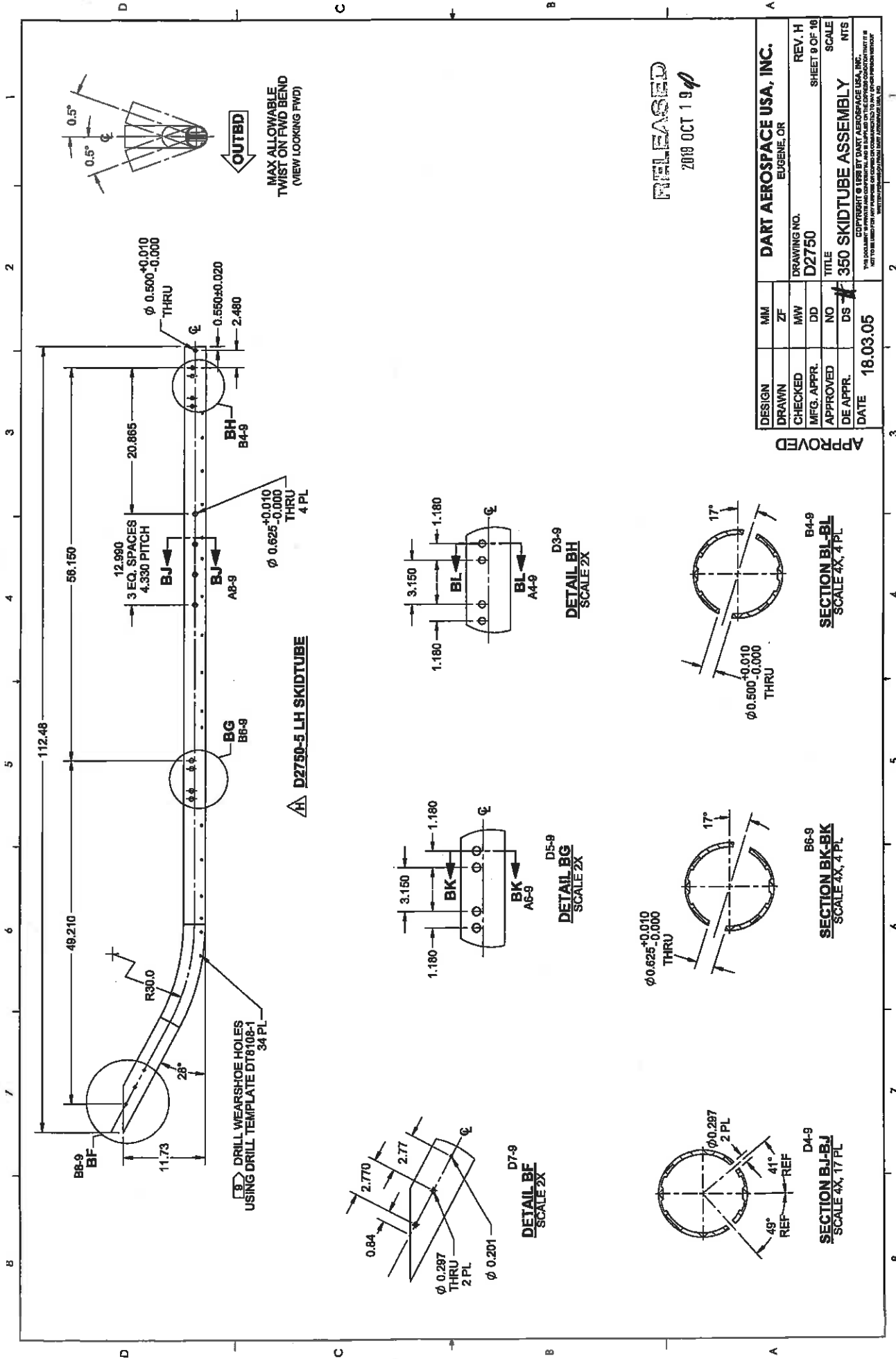
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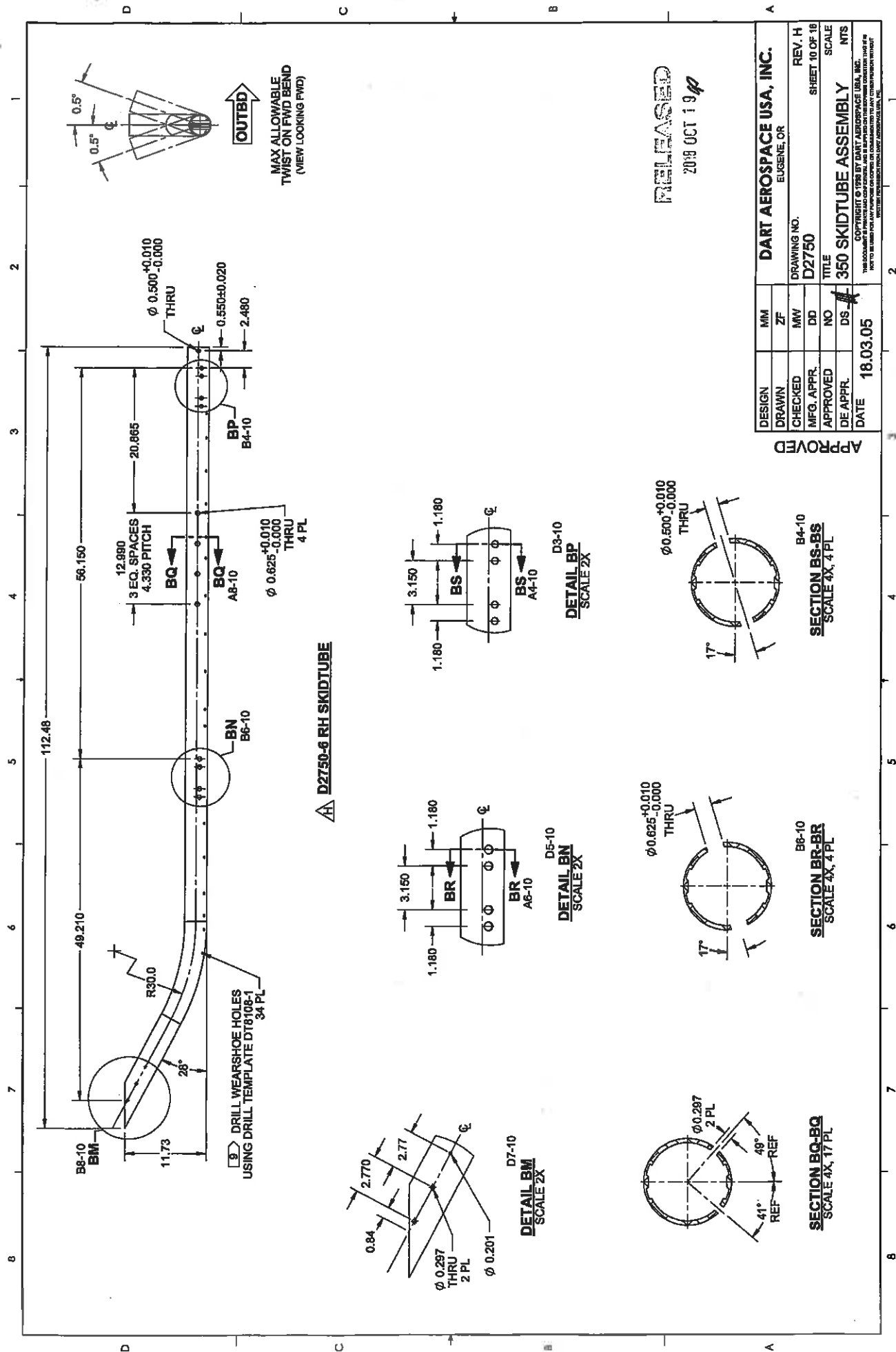
DESIGN	MM	DART AEROSPACE USA, INC. EUGENE, OR
DRAWN	ZF	
CHECKED	MW	
MFG. APPR.	DD	
APPROVED	NO	
DE APPR.	DS	REV. H SHEET 6 OF 18
DATE 18.03.05		DRAWING NO. D2750
DE APPR.		TITLE 350 SKIDTUBE ASSEMBLY
SCALE		NTS

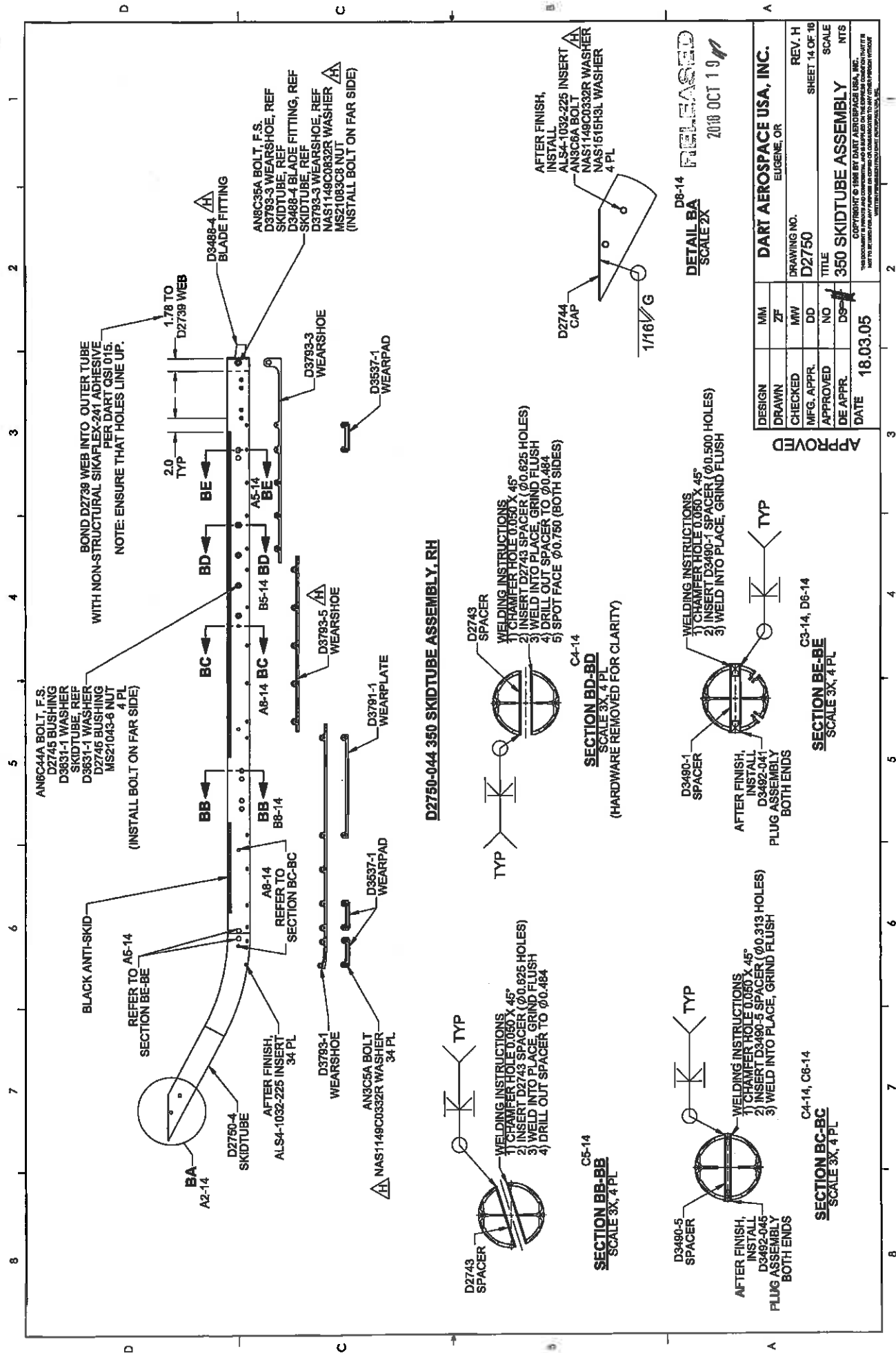
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PAGE 1 OF 1

Description: SKIDTUBE STD LH/RH, FLOAT COMPATIBLE

[illegible]